



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA10A-200
Job Sheet 178638



Part No: SWA10A-200

Job Qty: 20 ea

Part Name: Upper End Swivel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/5/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA10A-200 Rev7 IPP Rev A 17.12.14 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Machining-4		SL
110	Mori Seiki	20 pcs	6/22/18	6/22/18	0.00	20.00	MORI NLX		SL
120	QC	20 pcs	6/22/18	6/22/18	0.00	0.00	QC2		SL
130	QC	20 pcs	6/22/18	6/22/18	0.00	0.00	QC8		SL
140	Packaging	20 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3		SL
150	QC21-SA	20 Ea	6/22/18	6/22/18	0.00	0.00	QC21		SL

Part Op 110 - Cut Blanks to 7.06" 1-Machine as per DWG. FOLIO REV: 4A DWG REV: 21
Descriptions: 2-Deburr ***Machine engrave UP arrow*** PLEASE SEE PCL TO CHANGE

BATCH # FOR EVERY W/O

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R3.500	17-4 SS H1150 Round Bar 3.500"	11.6000 ft (.58 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R3.500	12	8	0

Part Specifications

Specifications could not be found.



Container No: S094924



Part: SWA10A-200

Job No: 178638

Serial No/Batch: S094924

Revision: 7

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 6/5/18 11:32 AM Dart.lajeunesse.marie

Date: 07/23/18

DART AEROSPACE LTD		Work Order:	178635
Description: upper end swivel		Part Number:	SWA10A-200
Inspection Dwg: SWA10A-200	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.700	±.005	2.698	/			
1.150	±.005	1.153	/			
.434	±.005	.434	/			
1.020	±.005	1.024	/			
.03x45°	±.01 ±.5°	.03x45°	/			
.04x45°	±.01 ±.5°	.04x45°	/			
.06x45°	±.01 ±.5°	.06x45°	/			
3/16-16UN2A						
major 3.493	±.0047	3.493	/			
minor 3.5204	±.0029	3.521	/			
1.125	±0 -.005	1.120	/			
6.843	±.005	6.838	/			
5.718	±.005	5.718	/			
1.350	±.005	1.350	/			
1.370	±.005	1.369	/			
R.13	±.01	R.125	/			
0.500	±.005	.500	/			
1.351 MINUS	±.005	1.35	/			
.820	±.005	.820	/			
3.70	±.01	3.70	/			
3.250	±.005 ±.01	3.25	/			
3.100	±.005	3.100	/			
R.13	±.01	.175	/			
R.02	±.01	.02	/			
.04x45°	±.01 ±.5°	.04x45°	/			
2.165	±.001	2.1645	/			
2.925	±.005	2.925	/			
2.069	±.005	2.069	/			

Measured by: JL	Checked by: [Signature]	QC Inspector:
Date: 18-7-25	Date: 18/8/01	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

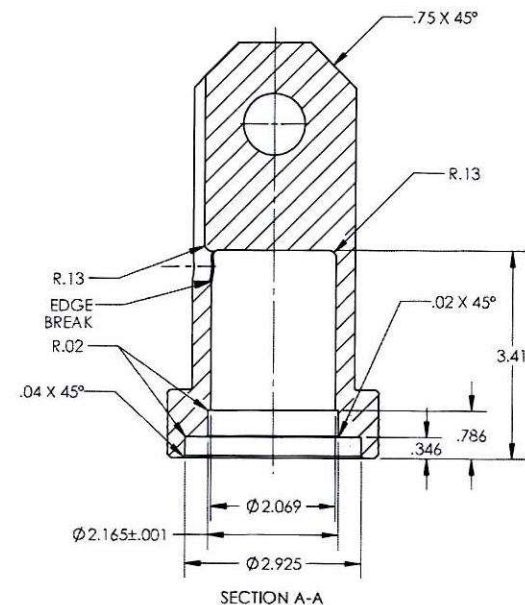
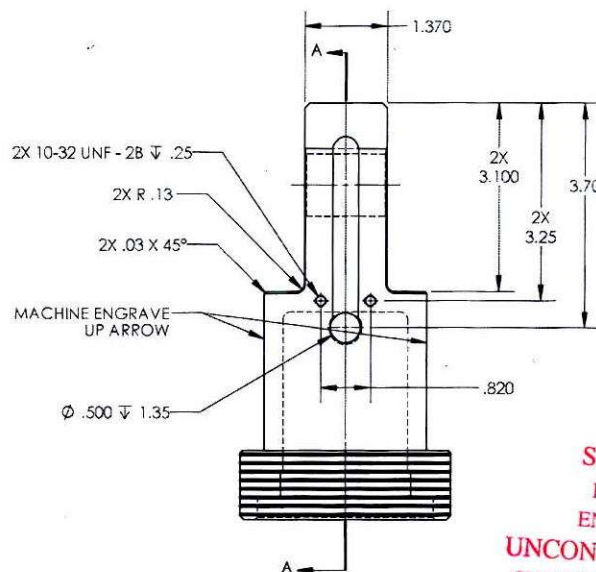
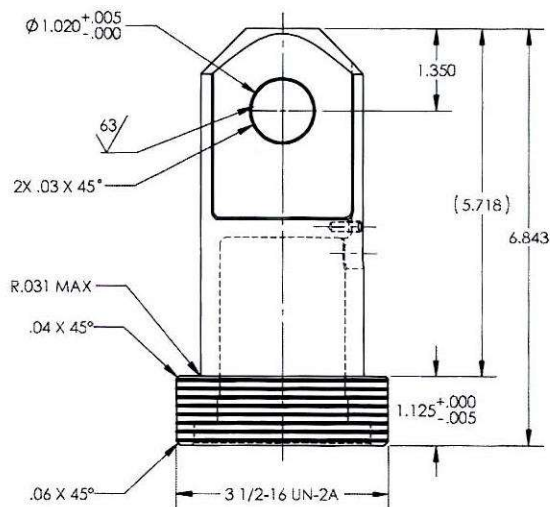
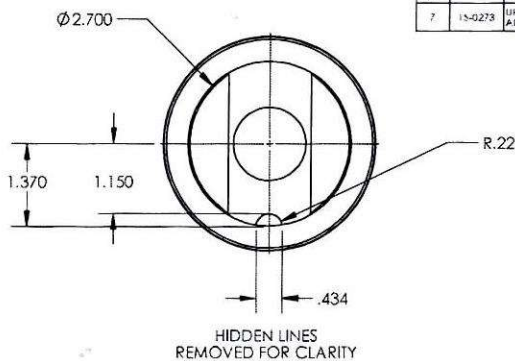
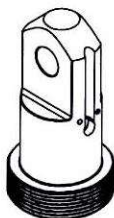


QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6		AS DRAWN BY CANAM	11/12/2012	JAG	
6A		CH D B/O INFO TO BLANK	4/29/2014	JAG	RW
7	13-0273	UPDATED TO NEW DRAFTING STANDARDS. ADDED UP ARROW NOTE. ADDED MAT L OPTION H1075. ADDED DIMS FROM SWA10A-200 BLANK DWG.	9/22/2015	OPD	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178638 MJS
1806-05

DART AEROSPACE	
TITLE UPPER END SWIVEL	
DWG NO. SWA10A-200	REV 7
MATL SS 17-4, H1150/H1075	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>P. Miel</i>
.XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/8 ANGLES ± 5° SPEC
1. BREAK ALL SHARP EDGES .015 X 45° 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 2/22/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA10A-200	1	UPPER END SWIVEL	SS 17-4, H1150/H1075	